

# Work Order ID 63336

Wednesday, October 27, 2010 3:52:00 PM



Page 1

Item ID: D2939-1UP

Accept



Setup Start



Revision ID:

Item Name: 206 Saddle Left side-unpainted

Stop



Start Date: 10/27/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 11/11/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: *H*

Date: *10-10-25*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2939	Rev C

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

*ack 10/11/25*

*6 0*

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

*ack 10/11/25*

*6 0*

120

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

*ack 10/11/25*

*6 0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_








NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			




**NOTE:** Date & initial all entries

**Work Order ID 63336**

Wednesday, October 27, 2010 3:52:00 PM

Page 2

Item ID:	D2939-1UP	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	206 Saddle Left side-unpainted					
Start Date:	10/27/2010	Start Qty:	6.00		Cust Item ID:	
Required Date:	11/11/2010	Req'd Qty:	6.00		Customer:	
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop
						

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		L.A 10/11/29		6	0		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00		EJH 10/11/29		X6	0		
150  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				6			BH 10-11-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries


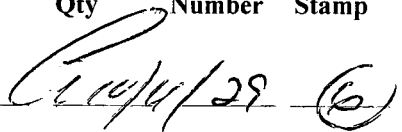

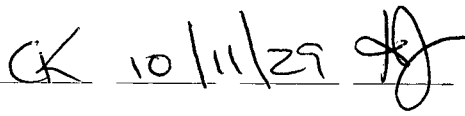
**Work Order ID 63336**

Wednesday, October 27, 2010 3:52:00 PM

Page 3

Item ID: D2939-1UP Accept  Setup Start   
Revision ID:  
Item Name: 206 Saddle Left side-unpainted Stop   
Start Date: 10/27/2010 Start Qty: 6.00  Cust Item ID:  
Required Date: 11/11/2010 Req'd Qty: 6.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Packaging Packaging	Identify as per dwg & Stock Location: <u>431</u>  Memo	0.00  0.00							<u>10/11/29</u> 
170  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							<u>CK 10/11/29</u>   MF 10-11-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, October 27, 2010 3:52:03 PM

Page 1

Work Order ID: 63336



Parent Item: D2939-1UP



Parent Item Name: 206 Saddle Left side-unpainted


Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 6.00

Required Qty: 6.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001  Saddle Billet		Manufactured	No			100	Each	4.0000	1	6			

### Location

### Loc Qty

### Loc Code

MAT40

4

61385

4

~~925~~ B63537x6 on 10/11/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	63334
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b>	D2939-1
<b>Inspection Dwg:</b> D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.115	.113	.113	.114	Vern	ML-7
B	0.100	0.140		.115	.117	.117	.114	"	"
C	0.100	0.140		.121	.122	.122	.123	"	"
D	0.210	0.230		.220	.220	.220	.220	"	"
E	1.245	1.255		1.249	1.249	1.249	1.249	"	"
F	1.245	1.255		1.249	1.249	1.249	1.249	"	"
G	2.495	2.505		2.499	2.499	2.499	2.499	"	"
H	0.510	0.515		.510	.510	.510	.511	"	"
I	1.572	1.582		1.575	1.575	1.576	1.578	"	"
J	2.495	2.505		2.499	2.500	2.499	2.500	"	"
K	0.257	0.262		.260	.260	.260	.260	"	"
L	0.312	0.317		.315	.315	.315	.315	"	"
M	0.235	0.240		.236	.236	.237	.236	"	"
N	0.100	0.140		.112	.113	.112	.112	Micro	118-120
O	0.540	0.560		.550	.549	.550	.550	Vern	ML-7
P	0.490	0.510		.500	.501	.501	.500	"	"
Q	3.715	3.725		3.718	3.718	3.717	3.718	"	"
R	2.720	2.760		2.740	2.740	2.740	2.740	"	"
S	0.240	0.270		.250	.250	.251	.253	"	"
T	0.100	0.180		.140	.140	.141	.141	"	"
U	1.625	1.635		1.629	1.629	1.628	1.628	"	"
V	1.362	1.372		1.366	1.366	1.366	1.366	"	"
W	0.316	0.321		.317	.317	.317	.317	"	"
X	1.250	1.270		1.260	1.260	1.260	1.258	"	"
Y	1.565	1.585	DT8695 A/B	1.572	1.573	1.573	1.570	"	"
Z	0.178	0.198		.188	.188	.188	.188	Rod gauge	R&D
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	me
Date:	10/11/25

Audited by:	H.A
Date:	10/11/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	63334
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b>	D2939-1
<b>Inspection Dwg:</b> D2939 Rev. C		Page 1 of 1

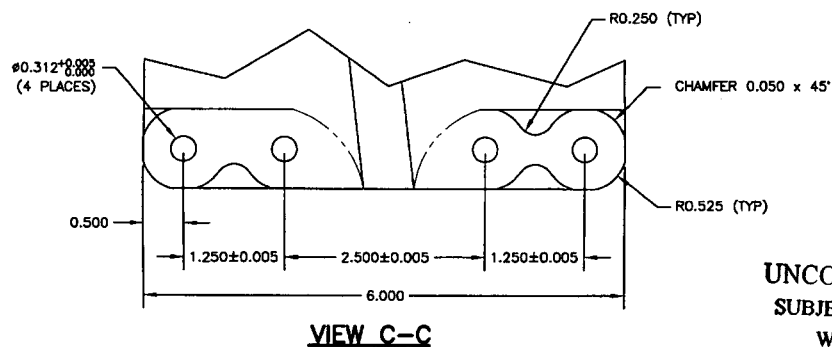
Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.114	.112			Vern	ML-7
B	0.100	0.140		.114	.118				
C	0.100	0.140		.122	.122				
D	0.210	0.230		.220	.222				
E	1.245	1.255		1.249	1.249				
F	1.245	1.255		1.249	1.249				
G	2.495	2.505		2.500	2.499				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.576	1.577				
J	2.495	2.505		2.499	2.499				
K	0.257	0.262		.260	.260				
L	0.312	0.317		.315	.315				
M	0.235	0.240		.236	.236				
N	0.100	0.140		.112	.115			Micro	118-120
O	0.540	0.560		.549	.549			Vern	ML-7
P	0.490	0.510		.500	.500				
Q	3.715	3.725		3.718	3.718				
R	2.720	2.760		2.740	2.741				
S	0.240	0.270		.250	.250				
T	0.100	0.180		.138	.139				
U	1.625	1.635		1.629	1.628				
V	1.362	1.372		1.366	1.366				
W	0.316	0.321		.317	.317				
X	1.250	1.270		1.259	1.261				
Y	1.565	1.585	DT8695 A/B	1.572	1.576				
Z	0.178	0.198		.188	.188			Red-page REF	
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	art
Date:	10/11/24

Audited by:	J.A
Date:	10/11/29

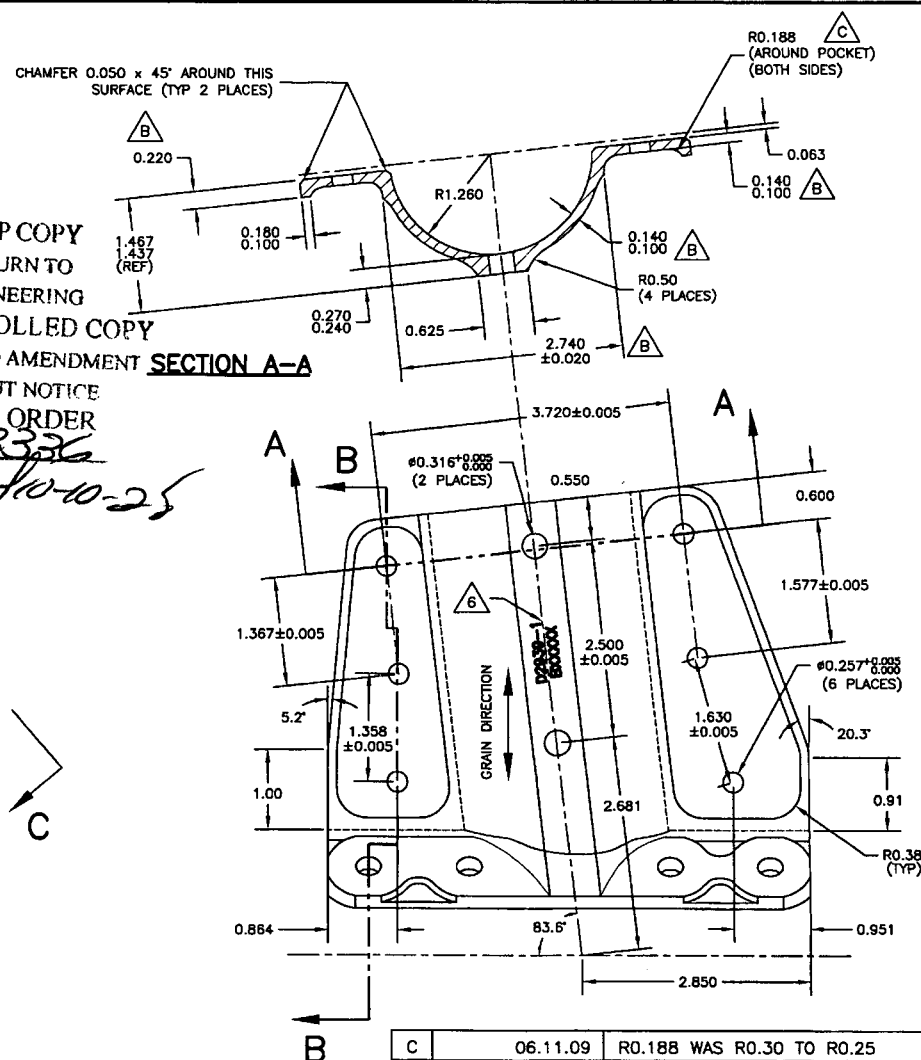
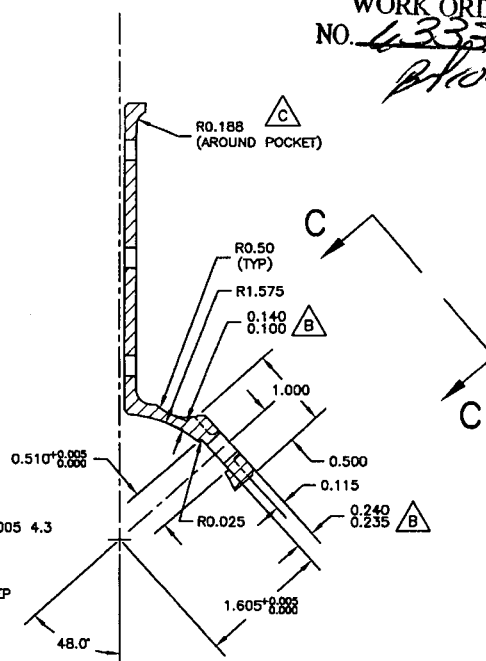
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



**D2939-1 LH SADDLE (SHOWN)**  
**D2939-2 RH SADDLE (OPPOSITE)**

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT **SECTION A-A**  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 43336  
210-10-25

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
  - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE INCHES
  - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



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 AND IS SUPPLIED ON THE EXPRESS CONDITION  
 THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
 OR COPIED OR COMMUNICATED TO ANY OTHER  
 PERSON WITHOUT WRITTEN PERMISSION FROM  
 DART AEROSPACE USA, INC.

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	APPROVED	DRAWING NO. D2939
DATE	TITLE	REV. C SHEET 1 OF 1 SCALE
06.11.09	SADDLE INSIDE	2.3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries